

Work Order ID 133388

133388

Page 1

Item ID: D350-607-511

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 6/02/15 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/08/15 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUN 09 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D350-607-4	C
DSI9699	A

MLJ 1507-07 2

100	Document Control	0.00	DAS 06 9-89						
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-511 CHG006								

DAS
02
9-89
JUL 08 2015

140	Pick Kit	0.00							
140									
Packaging	Memo	0.00							
Packaging									

DAS DAS
06 27
9-89 9-89
JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 133388

Monday, June 08, 2015 3:59:48 PM

133388

Page 2

Item ID: D350-607-511 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 6/02/15 Start Qty: 2.00 ***2*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 02 9-89
150	QC4- 100% Inspect kits for completeness	0.00							

150

QC

Memo

0.00

Quality Control

JUL 08 2015

160

160

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-511
 Location: **PK 15A**

2

CH 15-0708

DAS
02
9-89

170

170

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

MLJ JUL 08 2015

MLJ JUL 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																							
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Picklist Print

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Page 1

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Work Order ID: 133388

133388

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 6/02/15

Required Date: 6/08/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP
REV:B 13.12.30 PER RE:C ECN13-672 DD VERF:RQ IPP REV:C
14.06.09 AS PER ECN14-572 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3910-7		Manufactured	No				Each	19.0000	1	2			
D3910-7													
Crosstube Lug													

DAS
02
9-89

Location	Loc Qty	Loc Code
ST525	19	
120673	2	
129734	17	

DAS
27
9-89

D3501-1		Manufactured	No			140	Each	293.0000	8	16			
D3501-1													
Bushing													

DAS
02
9-89

Location	Loc Qty	Loc Code
ST046	172	
125925	1	
130742	171	
ST051A	121	
131169	121	

DAS
06
9-89

D3910-3		Manufactured	No			140	Each	73.0000	2	4			
D3910-3													
X-Tube Lug													

DAS
02
9-89

Location	Loc Qty	Loc Code
ST525A	73	
117781	73	

DAS
06
9-89

JUL 0 6 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 6/02/15

Required Date: 6/08/15

Start Qty: 2.00

Required Qty: 2.00

D3910-5 Manufactured No 140 Each 17.0000 1 2

D3910-5

Crosstube Lug

DAS
02
9-89

Location

Loc Qty

Loc Code

ST525

17

117637

11

132001

6

**

DAS
06
9-89

DAS
27
9-89

D3984 Manufactured No 140 f 114.0000 2 4

D3984

Rubber Extrusion, X-Tube, Per Foot

DAS
02
9-89

Location

Loc Qty

Loc Code

ST413

114

115196

14

132156

100

**

DAS
27
9-89

DAS
6
9-89

D4148-041 Manufactured No 140 Each 7.0000 1 2

D4148-041

Fwd Crosstube Lug Assembly

DAS
02
9-89

Location

Loc Qty

Loc Code

ST538

3

132676

3

ST539

4

129951

1

131058

1

131905

2

**

DAS
06
9-89

DAS
27
9-89

132677

D4149-041 Manufactured No 140 Each 5.0000 1 2

D4149-041

Aft X-Tube Lug Ass'y

DAS
02
9-89

Location

Loc Qty

Loc Code

ST539

5

129962

1

131915

4

**

DAS
06
9-89

DAS
27
9-89

132689

JUL 06 2015

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Picklist Print

Monday, June 08, 2015 3:59:47 PM

Page 3

Work Order ID: 133388

133388

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 6/02/15

Required Date: 6/08/15

Start Qty: 2.00

Required Qty: 2.00

D4775-041

Manufactured No

140

Each

24.0000

2

4

D4775-041

Strut Assembly

DAS
02
9-89

Location

Loc Qty

Loc Code

ST514

24

127656

1

128501

2

130019

8

131101

1

131941

2

132727

10

**

DAS
06
9-89

DAS
27
9-89

D4776-3

Manufactured No

140

Each

12.0000

2

4

D4776-3

Skidtube Clevis

DAS
02
9-89

Location

Loc Qty

Loc Code

ST127

12

~~130039~~

10

131799

2

**

132535

DAS
06
9-89

DAS
27
9-89

AN4-14A

Purchased No

140

Each

309.0000

20

40

AN4-14A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

ST325A

278

131677

2

M131153

5

M132189

71

M132317

200

ST344

26

M130716

15

M131803

11

**

DAS
06
9-89

DAS
27
9-89
JUL 06 2015

Monday, June 08, 2015 3:59:47 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
<table style="width:100%; border: none;"> <tr> <td colspan="2" style="text-align: center; border: none;">Root Cause</td> <td colspan="4" style="text-align: center; border: none;">FAULT CATEGORY</td> </tr> <tr> <td style="border: none; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="border: none; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="border: none; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="border: none; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="border: none; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="border: none; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> <tr> <td colspan="4" style="border: none; vertical-align: top;"> OTHER : _____ </td> </tr> </table>						Root Cause		FAULT CATEGORY				Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			
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OTHER : _____																					

Picklist Print

Monday, June 08, 2015 3:59:47 PM

Page 4

Work Order ID: 133388

133388

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 6/02/15

Required Date: 6/08/15

Start Qty: 2.00

Required Qty: 2.00

AN4-42A

Purchased

No

140

Each

68.0000

4

8

AN4-42A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

ST312A

68

M131320

28

M132317

40

**

DAS
06
9-89

DAS
27
9-89

AN6-13A

Purchased

No

140

Each

22.0000

2

4

AN6-13A

BOLT

DAS
02
9-89

Location

Loc Qty

Loc Code

ST334

22

m131305

22

**

DAS
06
9-89

DAS
27
9-89

MS21042L4

Purchased

No

140

Each

5,121.000

24

48

MS21042L4

Locknut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

26

m124231

26

GA

208

m127813

208

ST260a

4062

m130799

56

m131803

6

m132262

1000

m132382

3000

ST305

825

m128300

8

m130388

7

m130922

97

m131618

12

m132123

701

**

DAS
06
9-89

JUL 06 2015
DAS
27
9-89

Monday, June 08, 2015 3:59:47 PM

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
		OTHER : _____							

Picklist Print

Monday, June 08, 2015 3:59:47 PM

Page 5

Work Order ID: 133388

133388

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH

Start Date: 6/02/15

Required Date: 6/08/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L6

Purchased

No

140

Each

452.0000

2

4

MS21042L6

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

ST260a

200

m132262

200

ST273A

200

m131624

200

ST305

1

m129909

1

t260a

51

m131317

51

NAS1149F0432P

Purchased

No

140

Each

837.0000

40

80

NAS1149F0432P

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

ST260a

760

M131697

760

st268

77

M128995

63

M130388

14

NAS1149F0663P

Purchased

No

140

Each

96.0000

4

8

NAS1149F0663P

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

st268

96

M128591

2

M131317

94

DAS
06
9-89

DAS
27
9-89

DAS
06
9-89

DAS
27
9-89

DAS
06
9-89

JUL 06 2015

Monday, June 08, 2015 3:59:47 PM

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Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO 133388445
 1506-05

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

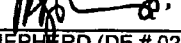
(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

- 3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.
- 3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole.
Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).
- 3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

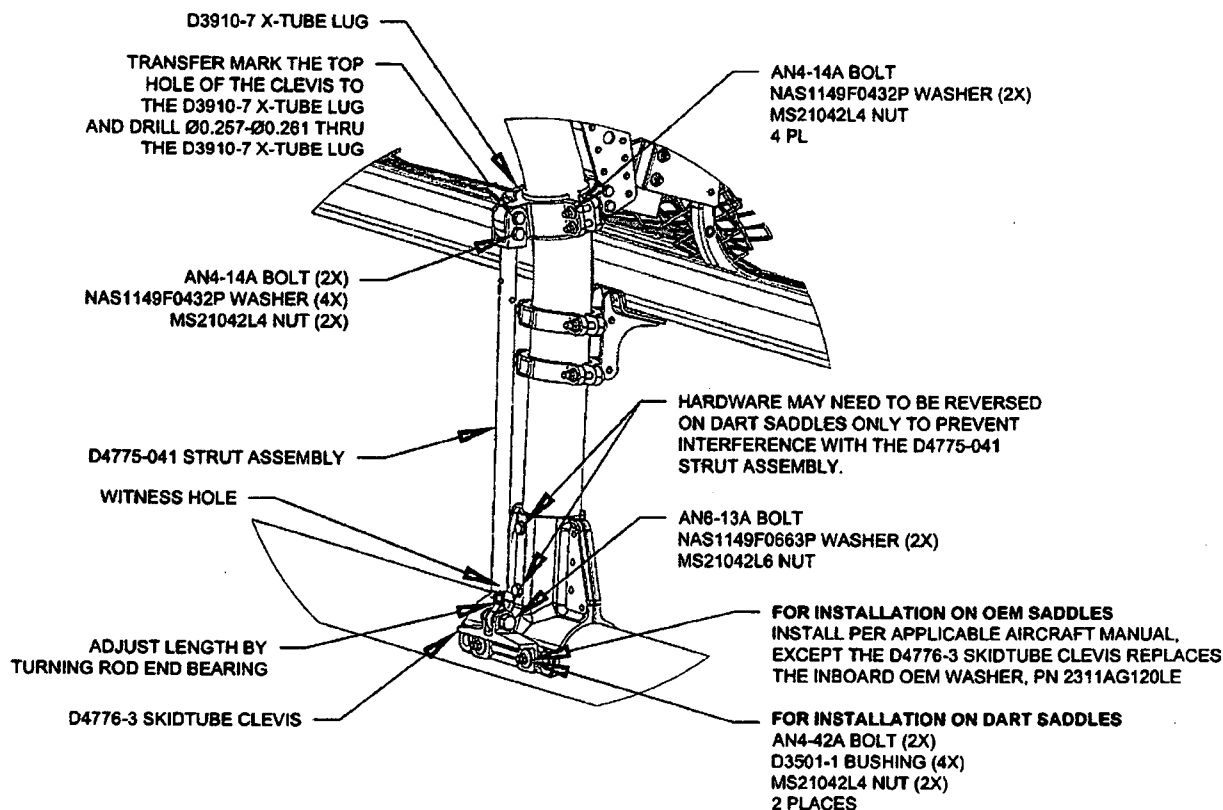


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE #02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

5.0 PARTS LIST

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
			X	D350-607-431	STRUT RETROFIT KIT
		8	8	D3501-1	BUSHING
		2		D3910-3	X-TUBE LUG
		2	2	D3910-5	X-TUBE LUG
1				D3912-041	EYEBOLT RECEIVER ASSY
4				D3917-3	WASHER
		8	4	D3984-030	RUBBER EXTRUSION, X-TUBE
		1		D4148-041	FWD X-TUBE LUG ASSY
		1		D4149-041	AFT X-TUBE LUG ASSY
1				D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
		2	2	D4775-041	STRUT ASSEMBLY
		2	2	D4776-3	SKIDTUBE CLEVIS
1				D4874-041	CARGO TUBE ASSEMBLY
1				D4875-043	CARGO TUBE AFT STRUT
1				D4875-045	FWD ATTACHMENT CLEVIS
			1	D4917-300	PLACARD MAX LOAD
			1	D4917-310	PLACARD MAX LOAD
			1	D4917-315	PLACARD, MAX LOAD
			1	D4917-320	PLACARD, MAX LOAD
			1	D4917-332	PLACARD, MAX LOAD
1				D5028-041	PLUG ASSEMBLY
1				D5031-041	LOCK PIN ASSY
2				AN310-4	CASTLE NUT
2				AN4-11	BOLT
4				AN4-13A	BOLT
		20	12	AN4-14A	BOLT
		4	4	AN4-42A	BOLT
		2	2	AN6-13A	BOLT
4	24	16		MS21042L4	NUT
	2	2		MS21042L6	NUT
2				MS24665-151	COTTER PIN
20	40	24		NAS1149F0432P	WASHER
	4	4		NAS1149F0663P	WASHER

1
as per
DSI

REFERENCE ONLY

DAS

02

9-89

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6

REF TCCA STC: SH94-14

REF FAA STC: SR00213NY

REF EASA STC: EASA.10016996

REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

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	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 14.05.16

CERT. NO.: SH94-14

ISSUE NO.: 6

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